Date

Monday, 25/08/2008 9:56:02 AM

.∗⊍ser:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 41611

Job Number **Estimate Number**

: 10313

P.O. Number

This Issue : 25/08/2008

: NC

Prsht Rev.

First Issue : 41436 Previous Run

: //

Type

S.O. No. :

: SMALL /MED FAB

Drawing Number

Drawing Name

Part Number

: D2648 REV D : N/A

Project Number **Drawing Revision**

Material

Due Date

: 10/09/2008

: WEARPAD

: D26483

Qty:

20 Um:

Each

Checked & Approved By

Comment

Written By

Re-format; Incorporated D2648-1 KJ/RF : Est: E 02.09.18

Est Rev:F Now on Waterjet 06-08-14

JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1010/1025 sheet 16GA

1.0

M1010S16GA

Comment: Qty.: 0.0788 sf(s)/Unit Total: 1010/1025/A21/6aA SHEET

(M1010S16GA)

1.5750 sf(s)

2.0

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Dwg Rev:_____D

Prog Rev: D

B 59-11

2-Deburr if necessary

3.0

QC2





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

SMALL FAB 1 5.0



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary







Page 1

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGE	S						
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No: PAR #:		PAR #:	Fault Cat	_ Fault Category: NC			CR: Yes No DQA: Date:				
		Dispositi	Disposition: Q								
NCR:		\	WORK ORI	DER NON-CONFORMA	NCE (NC	R)					
DATE	STEP	Description of NC	Corrective Action Section			Sign & Verifica					
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NOTE: Date & initial all entries

Monday, 25/08/2008 9:56:02 AM Date: User: Julie Lecocq **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: WEARPAD Job Number: 41611 Part Number: D26483 Job Number: Seq. #: Description: **Machine Or Operation:** BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 55 509/1 2-Identify as D2648-3 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R560Hardcoat M106762 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL INSPECTION OF GROUND WELDS 8.0 Comment: VISUAL INSPECTION OF GROUND WELDS 9.0 INSPECT WORK TO CURRENT STEP QC5 Comment: INSPECT WORK TO CURRENT STEP 10.0 106442 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: QC3 11.0 INSPECT POWDER COAT/CHEMICAL CON Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES			
DATE STEP		PRO	OCEDURE CHAI	NGE	By Date Qty			Approval QC Inspector
				•				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _	
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DATE	CTED	Description of NC			on B	Verification	Approval	Approval
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NOTE: Date & initial all entries

Date:

Monday, 25/08/2008 9:56:02 AM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 41611

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE



mr 68-09-23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aero	ospace	Ltd
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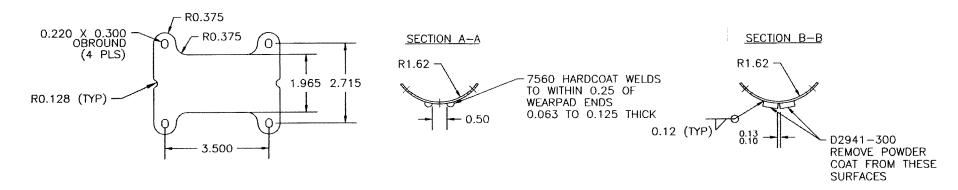
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DATE	STEP	Description of NC	Corrective Action Section Initial Action Description			Sign &		ation	Approval	Approval
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NOTE: Date & initial all entries

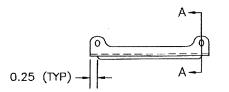
DART AEROSPACE LTD	Work Order:	4101
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648 Rev: D		Page 1 of 1

	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST				
	х	First Articl	е	Protot	уре				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
1.965	+/-0.010	1.968	*						
2.715	+/-0.010	2713	*						
3.500	+/-0.010	3,501	X						
0.220 x 0.300	+/-0.010 x +/-0.010	297 × 306							
R0.375	+/-0.010	~~~~	+						
R0.128	+/-0.010	- 138	*						
			-						
Managered by:	.50	Audited by:			Brototyne /	Approval: N/A			
Measured by:	13								
Date:	8-9-11	Date:				Date: N/A			
Rev Date	Change				Re	evised by Approved			
A 06.10.10	6 New Issue				Ku	J/JLM A CIA			

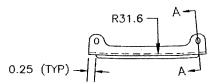
D2648-1 FLAT PATTERN



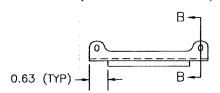




D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)







BREAK ALL SHARP CORNERS 0.063 MAX MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 CTOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NALL DIMENSIONS ARE IN INCHES

ON THE RESERVE OF THE PER DART QSI 003

ON THE DART QSI 003

ON THE

99,11.17 ADDED D2648-7 ¢ 97.06.26 R31.6 WAS R19.6 В ENLARGE OBROUND, 0.375 WAS 0.250 97.05.30 Α 97.03.25 NEW ISSUE DART AEROSPACE USA, INC. DART RF APPROVED D2648 SHEET 1 OF TITLE SCALE 99.11.17 WEARPAD

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